Work Order ID 121425

14 - ·

## \*121425\*

Page 1

Thursday, June 26, 2014 2:59:22 PM Accept Item ID: D3443-7 \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Tubing **Start Date:** 6/26/14 Start Oty: 3.00 **Cust Item ID:** Required Date: 6/26/14 Reg'd Oty: 3.00 **Customer:** Reference: Start Run Date: 14-06-27 Tooling: Approvals: Process Plan: 4L5 Date: Stop Date: QC: SPC (Y/N): Date: Reject Set Up/ Tool ID Tool# Plan Accept Reject Insp. Sequence ID/ Operation **Work Center ID** Code Qty **Qty** Number Stamp **Description Run Hours Draw Nbr Revision Nbr** D3443 Rev C 100 0.00 NOV 0 4 2014 NC BRAKE \*100\* Brake NC 0.00 9-89 1- Form as per Dwg D3443 using DT81172- Deburr per dwg D3443 Brake NC \*\*\*CUT 0.100" LONGER\*\*\* 0.00 110 Small Fab \*110\* Small Fab 0.00 Memo 9-89 Small Fab GRIND RAD PER DWG DAS 120 QC5- Inspect part completeness to step on W/O 0.0038 9-89 0.00Memo NOV 0 5/2014 Quality Control

| DQA:          | <u></u>                          | Date:    | Date: |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
|---------------|----------------------------------|----------|-------|----------|------------------------------|--------------------|----------------------------|--------------------|-----------|---------------|---------------|--------------------|--|--|--|
|               |                                  |          |       |          | WORK ORDER NON-              | ·CC                | ONFO                       | RMANCE / UI        |           | Vork Order ug |               | AEROSPACE          |  |  |  |
| QA Closed:    |                                  | Date:    |       |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
| Work Orde     | r.                               |          |       |          | DISPOSITION                  |                    | AGAINST DEPARTMENT/PROCESS |                    |           |               |               |                    |  |  |  |
| WOIR Olde     |                                  |          |       |          | Rework                       |                    |                            | Skid-tube          | Crosstube | $\neg$        | Water Jet     | Engineering        |  |  |  |
| Part N        | 0.                               |          |       |          | Scrap                        |                    |                            | Machining          | Small Fab | Pro           | d. Eng. Coor. | Quality            |  |  |  |
|               |                                  |          |       |          | Use-as-is                    |                    | Thern                      | noforming          | Finishing | Rec/Sto       | re/Packaging  | Other              |  |  |  |
| NCR No        |                                  |          |       |          | Suspected Unapproved         | Large Fab Composit |                            |                    |           |               | Supplier      | ] []               |  |  |  |
| Root          |                                  |          |       | Desci    | ription of work order update | Initial            |                            | Act                | ion       | Sign &        |               |                    |  |  |  |
| Cause         | Date                             | Step     | Qty   |          | or non-conformance           | Ch                 | ief Eng                    | Descr              | ription   | Date          | Verification  | QC Inspector       |  |  |  |
| Design        |                                  |          |       |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
| Doc/Data      |                                  |          |       |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
| Equip/Tooling | _                                |          |       |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
| Handling/Pre  |                                  |          |       |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
| Material      | _                                |          |       |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
| Operator      |                                  |          |       |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
| Offset/Setup  | . ,                              |          |       | 1        |                              | İ                  |                            |                    |           |               |               |                    |  |  |  |
| Process       |                                  |          | 1     |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
| Supplier      |                                  |          |       |          |                              | Ì                  |                            |                    |           |               |               | 1                  |  |  |  |
| Training      |                                  |          | 1     |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
| Transport     |                                  | 1        |       |          |                              | ŀ                  |                            |                    |           |               |               |                    |  |  |  |
| Unapproved    |                                  |          |       |          |                              |                    |                            |                    |           |               |               |                    |  |  |  |
|               | -                                |          |       |          |                              | ULT CA             | TEGORY                     |                    |           | ·             |               |                    |  |  |  |
| Landir        | ng Gear 🚶                        |          |       |          | General                      |                    |                            |                    | -         | <del></del> - | _             | _                  |  |  |  |
|               | Bending                          |          |       |          | Bend                         |                    | 4 `                        | Program            | ]-        | Outside Dim   | <del> </del>  | Pressure/Forced    |  |  |  |
| ļ             | Centre N                         | ot Conce | ntric |          | BOM/Route                    |                    | Grain                      |                    | _         | Over/Under    | <del>-</del>  | Set-up             |  |  |  |
|               | Cracks                           |          |       | ļ        | Broken/Damage/Defect         | ļ                  | Hardwa                     |                    |           | Part Incorre  | <b>—</b>      | Temperature/Cure   |  |  |  |
|               | Crimp/Kink/Ripple/Wave           |          |       |          | Burrs                        |                    | 4                          | ion Incomplete/Ur  | · ·       | Part Lost/M   | _             | Weld               |  |  |  |
|               | Cuffs                            |          |       |          | Contamination                | L                  | 4                          | tions Incomplete/l | Jnclear   | Part Moved    | L             | Wrong Stock Pulled |  |  |  |
| ļ             | Crushing                         |          |       |          | Countersink                  | L                  | 4 '                        | gned/off center    | 1         | Positioned \  |               | <b>-</b>           |  |  |  |
|               | Heat Treat                       |          |       | <u> </u> | Cut Too Short                | L                  | Mislab                     | eled               | L         | Power Loss/   | 'Surge        | Other              |  |  |  |
|               | Inspection Strip in Tube Drawing |          |       |          | -i                           | Misread            |                            |                    |           |               |               |                    |  |  |  |
|               | Marks/Chatter Drill Holes        |          |       |          |                              | Off-set            |                            |                    |           |               |               |                    |  |  |  |
|               | Turning Sequence Finish          |          |       |          | L                            | Out of             | Calibration                |                    |           |               |               |                    |  |  |  |
|               | Wave/Twist in Tube Fit/Fu        |          |       |          | Fit/Function                 | <u>L</u>           | Out of                     | Out of Sequence    |           |               |               |                    |  |  |  |

| Work Ord<br>Thursday, June                 |                              |                                    |                 | *121                            |                          |            |              | Page 2        |               |                  |                |                      |
|--|------------------------------|------------------------------------|-----------------|---------------------------------|--------------------------|------------|--------------|---------------|---------------|------------------|----------------|----------------------|
| Item ID:<br>Revision ID:<br>Item Name:     | D3443-7 Tubing               |                                    |                 | Accept                          | *N900                    | <b>040</b> | 100          | ን* ፡          | _             |                  | S1*<br> S2*    |                      |
| Start Date:<br>Required Date<br>Reference: | 6/26/14<br>e: 6/26/14        | Start Qty: 3.00<br>Req'd Qty: 3.00 | *3*             |                                 | Cust Item I<br>Customer: | D:         |              |               |               |                  |                |                      |
| Approvals: Process P                       |                              | lan:                               | Date:           | Tooling: SPC (Y/N):             | Date:                    |            |              | I             |               | op               | R1*            |                      |
| Sequence ID/<br>Work Center                | ID                           | Operation<br>Description           |                 | Set Up/<br>Run Hours            | Tool ID                  | Tool #     | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |                      |
| *120*<br>Mill Conv                         | ing Machine                  |                                    |                 | 0.00<br>s per dwg D34432-Deburr | as per dwg               |            |              | _3            | _Ø_           |                  | J.C.L.         | 20<br>9-8:<br>[H-1(- |
| 140  | <del>-</del> . <del></del> . | D3443  QC2- Inspect parts off m    | achine FAI/FAIB | 0.00                            | <del>-</del>             |            |              |               |               | - <del>-</del>   |                | /DA                  |

DAS OB 98E

0.00

0.00

0.00

Memo

QC8- Inspect parts - second check

Memo

\*140\*

Quality Control

\*150\*

Quality Control

150

| DQA:          |                          | _ Date:     |        |             |                              |                   |                  |                            |          |              |               | TRACE              |
|---------------|--------------------------|-------------|--------|-------------|------------------------------|-------------------|------------------|----------------------------|----------|--------------|---------------|--------------------|
| •             |                          |             |        |             | WORK ORDER NON-              | -CC               | ONFO             | RMANCE / UPDATE            |          |              |               | AEROSPACE          |
| QA Closed:    |                          | Date:       |        |             |                              |                   |                  |                            | W        | ork Order up | date only     |                    |
| Work Orde     | r·                       |             |        | -           | DISPOSITION                  |                   |                  | AGAINST                    | :        |              |               |                    |
| WOIR Olde     | ٠٠                       |             |        | -           | Rework                       | ıİ                | ·                | Skid-tube Crosstube        | _        | ]            | Water Jet     | Engineering        |
| Part N        | 0.                       |             |        |             | Scrap                        |                   |                  | Machining Small Fab        | -        | Pro          | d. Eng. Coor. | Quality            |
|               |                          |             |        |             | Use-as-is                    |                   |                  | noforming Finishing        |          | 4            | re/Packaging  | Other              |
| NCR N         | o                        |             |        |             | Suspected Unapproved         |                   | Large Fab Compos |                            |          | ]            | Supplier      |                    |
| Root          |                          |             |        | Desci       | ription of work order update |                   | nitial           | Action                     |          | Sign &       |               |                    |
| Cause         | Date                     | Step        | Qty    |             | or non-conformance           | Ch                | ief Eng          | Description                |          | Date         | Verification  | QC Inspector       |
| Design        |                          |             |        |             |                              |                   |                  |                            |          |              |               |                    |
| Doc/Data      |                          |             |        |             |                              | İ                 |                  |                            |          |              |               |                    |
| Equip/Tooling |                          |             |        |             |                              | •                 |                  |                            |          |              |               |                    |
| Handling/Pre  |                          |             |        |             |                              |                   |                  |                            |          |              |               |                    |
| Material      | _                        |             |        |             |                              |                   |                  |                            |          |              |               |                    |
| Operator      | _                        |             |        |             |                              |                   |                  |                            |          |              |               |                    |
| Offset/Setup  | _                        |             |        |             |                              |                   |                  |                            |          |              |               |                    |
| Process       |                          |             |        |             |                              |                   |                  |                            |          |              |               |                    |
| Supplier      |                          |             |        |             |                              |                   |                  |                            |          |              |               |                    |
| Training      |                          |             |        |             |                              |                   |                  |                            |          |              |               |                    |
| Transport     |                          |             |        |             |                              |                   |                  |                            |          |              |               |                    |
| Unapproved    |                          | <u> </u>    |        |             |                              |                   |                  |                            |          |              |               |                    |
|               |                          |             |        |             |                              | FAI               | ULT CA           | TEGORY                     |          |              |               |                    |
| Landir        | g Gear                   |             |        | _           | General                      | _                 | ,                |                            | _        | 7            | _             | <b>-</b>           |
|               | Bending                  |             |        |             | Bend                         | <u> </u>          | 1                | Program                    | _        | Outside Dim  | <u> </u>      | Pressure/Forced    |
|               | Centre N                 | ot Conce    | ntric  |             | BOM/Route                    | L                 | Grain            |                            |          | Over/Under   | <u> </u>      | Set-up             |
| ·             | Cracks                   |             |        |             | Broken/Damage/Defect         | L                 | Hardwa           |                            | <b>L</b> | Part Incorre | <b>⊢</b>      | Temperature/Cure   |
|               | Crimp/Ki                 | nk/Ripple   | e/Wave | $\perp$     | Burrs                        | <u></u>           | • •              | ion Incomplete/Unqualified | <u> </u> | Part Lost/M  | issing        | Weld               |
|               | Cuffs                    |             |        |             | Contamination                | <u></u>           | 4                | tions Incomplete/Unclear   | <u></u>  | Part Moved   | L             | Wrong Stock Pulled |
|               | Crushing                 |             |        |             | Countersink                  | $ldsymbol{f eta}$ | 4                | gned/off center            | L        | Positioned V | _             | ¬₋.                |
|               | Heat Treat               |             |        |             | Cut Too Short                | _                 | Mislab           |                            | L        | Power Loss/  | Surge         | Other              |
|               | Inspection Strip in Tube |             |        |             | Drawing                      | <u></u>           | Misrea           |                            |          |              | <del></del>   |                    |
|               |                          |             |        | Drill Holes | L_                           | Off-set           |                  |                            |          |              |               |                    |
|               |                          |             |        |             | Finish                       |                   | -                | Calibration                |          |              |               |                    |
|               | Wave/Tv                  | vist in Tul | be     |             | Fit/Function                 |                   | Out of Sequence  |                            |          |              |               |                    |

| Work Ore                                   |                        | 21425  |                    | *12                  |                       |       |              |               | Page 3            |               |                  |                |
|--|------------------------|--|--------------------|----------------------|-----------------------|-------|--------------|---------------|-------------------|---------------|------------------|----------------|
| Item ID:<br>Revision ID:<br>Item Name:     | D3443-7 Tubing         |  |                    | Accept               | *N900                 | 040   | 1100         | )*            | Setup             | Start<br>Stop |                  | S1*<br>S2*     |
| Start Date:<br>Required Date<br>Reference: | 6/26/14<br>se: 6/26/14 | Start Qty: 3.00<br>Req'd Qty: 3.00             | *3*<br>*3*         |                      | Cust Item 1 Customer: | ID:   |              |               | _                 | G             |                  | •              |
| Approvals:                                 |                        | Process Plan:QC:                               |                    | Tooling: SPC (Y/N):  | Date:Date:            |       |              |               | Run               | Start<br>Stop | *NI              | R1*<br>R2*     |
| Sequence ID/<br>Work Center<br>160         | ID                     | Operation Description Identify as per dwg & St | ock Location:WAC   | Set Up/<br>Run Hours | Tool ID               | Tool# | Plan<br>Code | Accept<br>Qty | Rej<br>Qty        |               | Reject<br>Number | Insp.<br>Stamp |
| *160* Packaging Packaging                  | <del></del> -          | Memo   |                    | 0.00                 |                       |       |              | 3             | DAS<br>66<br>8-89 |               | DEC 0 5          | 2014           |
| <sup>170</sup><br><b>*17∩*</b>             |                        | QC21- Final Inspection                         | Work Order Release | 0.00                 | <del>-</del>          |       |              |               | -                 | -<br>141      | -<br>12/1        | 921            |
| QC   |                        | Memo   |                    | 0.00                 |                       |       |              |               |                   |               | <del></del>      | -//            |

Memo

Quality Control

**Picklist Print** 

Thursday, June 26, 2014 2:59:22 PM

Work Order ID: 121425

\*121425\*

Parent Item:

D3443-7

\*D3443-7\*

Parent Item Name: Tubing

**Start Date:** 6/26/14

Required Date: 6/26/14

Page 1

Start Qty: 3.00

Required Qty: 3.00

**Comments:** 

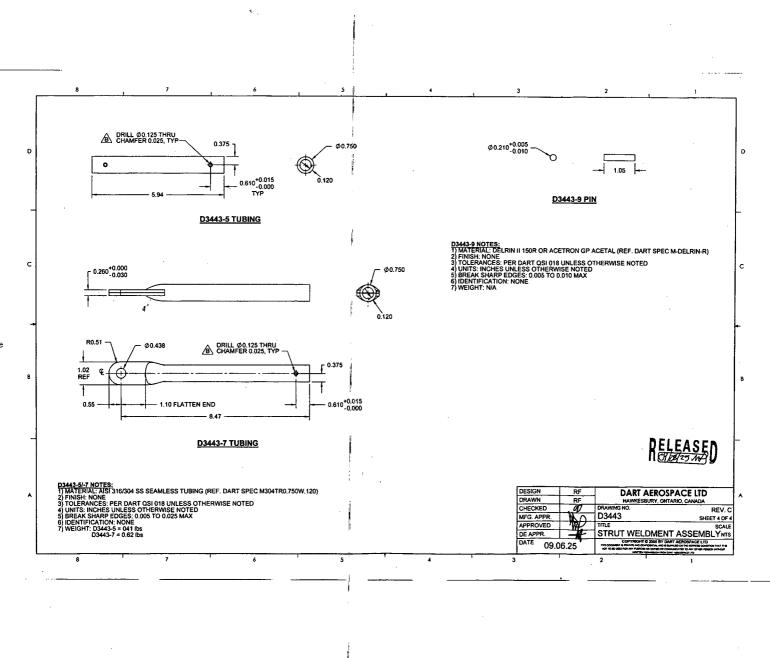
A05.11.14New issueEC

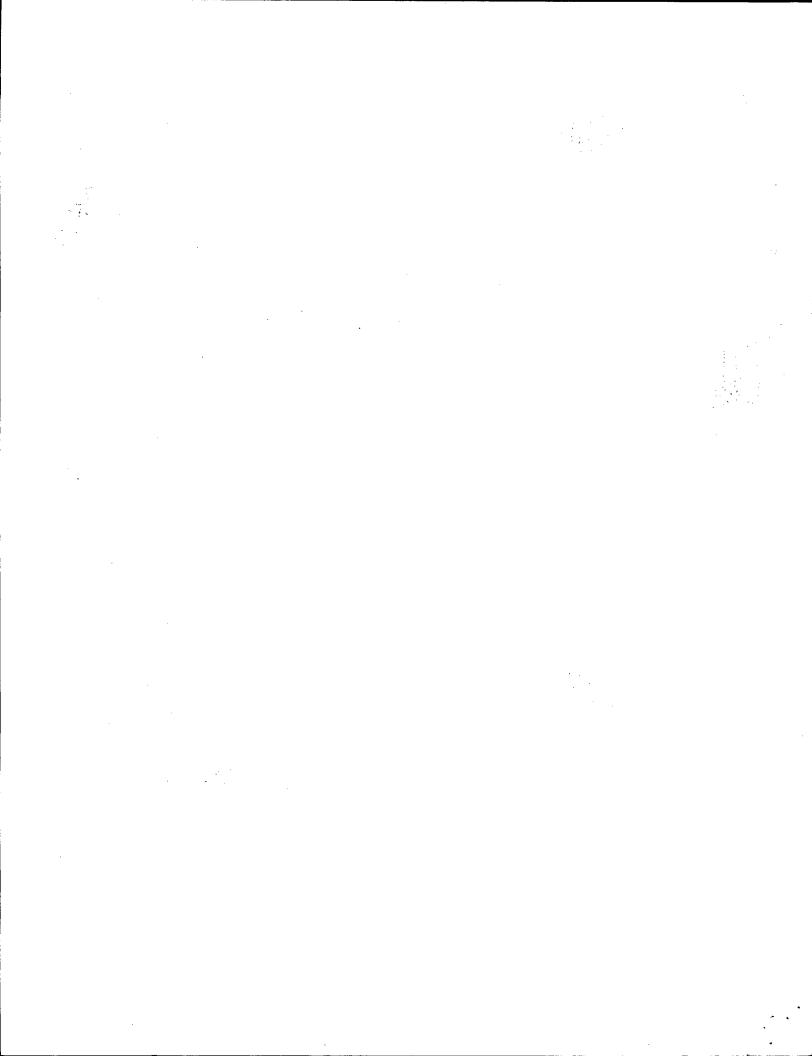
| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch  | Bin<br>Item | Primary<br>Location       | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued     | Date<br>Issued | Status     |
|---------------------------------|------------------------|----------------|-------------|---------------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|-------------------|----------------|------------|
| *M304TR0.750W.120               |                        | Purchased 120* | No          |                           |                  | 100             | f                  | 13.3474        | 0.75        | 2.368421     | DAS<br>28<br>9-89 | NO             | V 0 4 2014 |
| 304 ss round tube .750 x .17    | 20w                    |                |             | <u>Location</u><br>MAT017 |                  | <u>Loc</u> :    | <u>Oty</u><br>3474 | Loc Code       |             | 13007/       | ,                 |                |            |

13.3474

125656

| DQA:               |  |                        | . Date:   |       |                      |   |                    |           |                            |             |                  |              |   |                    |  |
|--------------------|--|------------------------|-----------|-------|----------------------|---|--------------------|-----------|----------------------------|-------------|------------------|--------------|---|--------------------|--|
|                    |  |                        |           |       |                      | WORK ORDER NON-                                 | -CC                | ONFO      | RMANCE / UPDATE            |             |                  |              | _ | AEROSPACE          |  |
| QA Closed:         |  |                        | Date:     |       |                      |   |                    |           |                            | Wo          | ork Order up     | date only    |   |                    |  |
| Work Orde          | er:                                    |                        |           |       |                      | DISPOSITION                                     |                    |           | AGAINS                     | ST DE       | PARTMENT         | /PROCESS     |   | <b>*</b>           |  |
|                    |  |                        |           |       |                      | Rework  |                    |           | Skid-tube Crosstub         | ьеГ         | Water Jet        |              |   | Engineering        |  |
| Part N             | lo.                                    |                        |           |       |                      | Scrap   |                    | 1         | Machining Small Fa         |             | Prod. Eng. Coor. |              |   | Quality            |  |
|                    |  |                        |           |       |                      | Use-as-is                                       |                    | Thern     | noforming Finishir         | ng          | Rec/Stor         | re/Packaging |   | Other              |  |
| NCR No.            |  |                        |           |       | Suspected Unapproved |   | Large Fab Composit | te        |                            | Supplier    |                  |              |   |                    |  |
| Doot               | -                                      |                        | 1         | 1     | Doss                 | rintian of work order undate                    |                    | nitial    | Action                     |             | Sign &           | <u> </u>     | 一 |                    |  |
| Root               |  | Date                   | Ston      |       | Desc                 | ription of work order update or non-conformance | l                  | ief Eng   | Description                |             | Date             | Verification | , | QC Inspector       |  |
| Cause              | $\dashv$                               | Date                   | Step      | Qty   |                      | or non-comormance                               | CII                | iei ciig  | Description                |             | Date             | Vermeation   | 늭 | Qe mapeetor        |  |
| Design<br>Doc/Data | $\dashv$                               |                        |           |       |                      |   |                    |           |                            |             |                  | .e.          | ١ |                    |  |
| Equip/Tooling      | $\dashv$                               |                        |           |       |                      |   |                    |           |                            |             |                  |              |   |                    |  |
| Handling/Pre       | _                                      |                        |           | ·     |                      |   |                    |           | H                          |             |                  |              |   |                    |  |
| Material           | $\dashv$                               |                        | <b>.</b>  |       |                      |   |                    |           |                            |             | ,                |              | 1 |                    |  |
| Operator           |  |                        |           |       |                      |   |                    |           |                            |             |                  |              |   |                    |  |
| Offset/Setup       |  |                        |           |       |                      | ٠.  |                    |           |                            |             |                  |              |   |                    |  |
| Process            |  |                        |           |       |                      | •   |                    |           |                            |             |                  | ,            |   |                    |  |
| Supplier           |  |                        |           |       |                      |   |                    |           |                            |             |                  | •            |   |                    |  |
| Training           |  |                        |           |       |                      | •.  |                    |           |                            |             |                  |              |   |                    |  |
| Transport          | -                                      |                        |           |       |                      |   |                    |           |                            |             |                  |              |   |                    |  |
| Unapproved         | Ĭ                                      |                        |           |       | ļ′                   |   |                    |           |                            |             | 1                |              |   |                    |  |
|                    |  | ,                      |           |       |                      |   | FAI                | ULT CA    | regory                     |             |                  |              |   |                    |  |
| Landi              | ng G                                   | ear                    |           |       |                      | General   |                    |           |                            |             | •                | -            |   |                    |  |
|                    |  | Bending                |           |       |                      | Bend  |                    | Folio/F   | rogram                     | <u> </u>    | Outside Dim      | ensions      | - | Pressure/Forced    |  |
|                    |  | Centre No              | ot Concer | ntric |                      | BOM/Route                                       | <u> </u>           | Grain     |                            | $\perp$     | Over/Under       | l l          |   | Set-up             |  |
|                    |  | Cracks                 |           |       |                      | Broken/Damage/Defect                            |                    | Hardwa    |                            |             | Part Incorre     |              |   | Temperature/Cure   |  |
|                    | -                                      | Crimp/Kink/Ripple/Wave |           |       |                      | Burrs   |                    | 1 '       | ion Incomplete/Unqualified | <u> </u>    | Part Lost/Mi     | issing       |   | Weld               |  |
|                    | -                                      | Cuffs                  |           |       | _                    | Contamination                                   | _                  | 4         | ions Incomplete/Unclear    | <u> </u>    | Part Moved       | l            |   | Wrong Stock Pulled |  |
|                    | Crushing                               |                        |           |       |                      | Countersink                                     | <u>_</u>           | • •       | gned/off center            | $\vdash$    | Positioned V     |              |   | l                  |  |
|                    | Heat Treat                             |                        |           |       | <u> </u>             | Cut Too Short                                   | <u></u>            | Mislabe   |                            |             | Power Loss/      | Surge        |   | Other              |  |
|                    | Inspection Strip in Tube               |                        |           | Tube  | Drawing              |   | Misrea             |           |                            | <del></del> |                  | _            |   |                    |  |
|                    | —————————————————————————————————————— |                        |           |       | <u> </u>             | Drill Holes                                     |                    | Off-set   |                            |             |                  |              | _ |                    |  |
|                    | Turning Sequence                       |                        |           |       | L                    | Finish  | <u></u>            | 4         | Calibration                |             |                  |              |   |                    |  |
|                    | Wave/Twist in Tube                     |                        |           |       | - 1                  | Fit/Function                                    | 1                  | IOut of : | Seauence                   |             |                  |              |   |                    |  |





| ART AEROSPACE LTD          | Work Order: 121 425  |
|----------------------------|----------------------|
| JART AEROSPACE LID         |                      |
| Description: Tubing        | Part Number: D3443-7 |
| . V                        | Page 1 of 1          |
| nspection Dwg:03443 Rev: C |                      |

## FIRST ARTICLE INSPECTION CHECKLIST

|                      |                    | <del></del>      | T      |        | I                       |          |
|----------------------|--------------------|------------------|--------|--------|-------------------------|----------|
| Drawing<br>Dimension | Tolerance          | Actual Dimension | Accept | Reject | Method of<br>Inspection | Comments |
| 8.471                | t- 0.030           | 8.460            | V      | į.     | Caliper                 | A 1000   |
| 0.55                 | t-0.030            | 0.560            | V      | ļ      | Caliper                 | JCL-08   |
| 0.610                | 40.015             | 0.614            | U      |        | ίι                      |          |
| 80.125               | -0.000<br>+ d. 000 | 0.126            | U      |        | 1(                      |          |
| Ø 0,438              | + 0.00b<br>-0.001  | 0.438            | J      | !      | η                       |          |
| 0.200                | t 0.000<br>-0.030  | 0.257            | V      | 3      | 1(                      |          |
| Ø 0.750              | 4-0.010            | 0.748            | V      |        | 11                      |          |
| 0-120                | \$ 0.010           | 0.112            | V      |        | 11                      |          |
| 1.02 (Ref.)          | \$ 0.030           | 1.027            | V      |        | 11                      |          |
|                      |                    |                  |        |        |                         |          |
|                      |                    |                  |        |        |                         |          |
|                      |                    |                  |        |        |                         |          |
|                      |                    |                  |        | ]      |                         |          |
|                      |                    |                  |        |        |                         |          |
|                      |                    |                  |        |        |                         |          |
|                      |                    |                  |        | !      |                         |          |
|                      |                    |                  |        |        |                         |          |
|                      |                    |                  |        |        |                         |          |
|                      |                    |                  |        |        |                         |          |
|                      |                    |                  | -      |        |                         |          |
|                      |                    |                  | 1      |        |                         | ·        |
|                      |                    |                  | ŕ      |        |                         |          |
|                      |                    |                  | ,      |        |                         |          |
|                      | <u> </u>           | L                |        |        |                         |          |

|       |          |         | 7         |             |          |      |                       |          |
|-------|----------|---------|-----------|-------------|----------|------|-----------------------|----------|
| Moasi | ured by: | 7 / L.  | DAS<br>20 | Audited by: | ۵.۵      |      | Preliminary Approval: |          |
| Wieas |          | 0.01    | 9-89      | Date:       | 11.0 0.1 | 08   | Date:                 |          |
|       | Date: 1  | 4/1/26/ | 14-11-26  | Date.       | 17/1407  | 9-89 |                       |          |
|       |          |         |           |             |          |      | Revised by            | Approved |
| Rev   | Date     | Change  |           |             |          |      | KJ                    |          |
| E     | 10.04.14 | Added p | reliminar | y approval  |          |      | 1.19                  |          |

\$ 10.04.15

| DQA:                 |                          | Date:       |        |             | WORK ORDER NON-CONFORMANCE / UPDATE  |                    |  |                   |            |          |                     |             |    |                     |
|----------------------|--------------------------|-------------|--------|-------------|--|--------------------|--|-------------------|------------|----------|---------------------|-------------|----|---------------------|
| QA Closed:           |                          | Date:       |        |             | WORK ORDER NON   | -((                | JNFO                                     | RIVIANCE / UP     |            | Wo       | rk Order up         | date only   |    | AEROSPACE           |
| Work Orde            | or.                      |             |        |             | DISPOSITION  |                    |  |                   | AGAINST [  | DEP      | ARTMENT             | PROCESS     |    |                     |
|                      | Part No.                 |             |        |             | Rework Scrap   |                    | Skid-tube Crosstube  Machining Small Fab |                   |            |          | Prod. Eng. Coor.    |             |    | Engineering Quality |
| NCR N                | lo                       | •           |        |             | Use-as-is Thermoforming Finishing Suspected Unapproved Large Fab Composite |                    |  |                   | ~ <u> </u> |          |                     |             |    | Other               |
| Root                 |                          |             |        | Desc        | ription of work order update   | ı                  | nitial                                   | Acti              | on         |          | Sign &              |             |    |                     |
| Cause                | Date                     | Step        | Qty    |             | or non-conformance   | Ch                 | ief Eng                                  | Descri            | ption      |          | Date                | Vềrificatio | on | QC Inspector        |
| Design               | _                        |             |        |             |  |                    |  |                   |            |          | ,                   |             |    | :                   |
| Doc/Data             |                          |             |        | •           |  |                    | ,  |                   |            |          |                     |             |    |                     |
| Equip/Tooling        |                          |             |        |             |  |                    | ,  |                   | •          |          |                     |             | ٠, |                     |
| Handling/Pre         | -                        |             |        |             |  |                    |  |                   |            |          |                     | !           |    |                     |
| Material<br>Operator |                          |             |        |             |  |                    |  |                   |            |          |                     |             |    |                     |
| Offset/Setup         |                          |             |        |             |  |                    |  |                   |            |          |                     |             |    |                     |
| Process              |                          |             |        |             |  |                    |  |                   |            |          |                     | · C.        |    |                     |
| Supplier             |                          | 1           |        |             |  |                    |  |                   |            |          |                     | -           |    |                     |
| Training             |                          |             |        |             |  |                    |  |                   |            |          |                     |             |    |                     |
| Transport            |                          |             |        |             |  |                    |  |                   |            |          |                     |             |    | ,                   |
| Unapproved           |                          |             |        |             |  |                    |  |                   |            |          |                     |             |    |                     |
|                      |                          | •           |        | <del></del> |  | FAl                | JLT CA                                   | regory            |            |          |                     |             |    |                     |
| Landir               | ng Gear                  |             |        |             | General  |                    |  |                   |            |          |                     | ,           |    |                     |
|                      | Bending                  |             |        | ,           | Bend   |                    | Folio/F                                  | rogram -          |            |          | Outside Dim         | ensions     |    | Pressure/Forced     |
|                      | Centre No                | ot Conce    | ntric  |             | BOM/Route  |                    | Grain                                    |                   |            | (        | Over/Under          | tolerance   |    | Set-up              |
|                      | Cracks                   |             |        |             | Broken/Damage/Defect   |                    | Hardwa                                   | re                |            | <u>`</u> | Part Incorrec       | t           |    | Temperature/Cure    |
|                      | Crimp/Ki                 | nk/Ripple   | e/Wave |             | Burrs  |                    | Inspect                                  | ion Incomplete/Un | qualified  | F        | Part Lost/Mis       | ssing       |    | Weld <sub>.</sub>   |
| ļ                    | Cuffs                    |             |        |             | Contamination  |                    | Instruct                                 | ions Incomplete/U | nclear     | f        | Part Moved          |             |    | Wrong Stock Pulled  |
|                      | Crushing                 |             |        |             | Countersink  | -                  | 1  | ned/off center    |            | -        | Positioned <b>W</b> | -           |    |                     |
|                      | Heat Treat               |             |        |             | Cut Too Short  |                    | Mislabe                                  | eled              |            |          | Power Loss/S        | Surge       |    | Other               |
|                      | Inspection Strip in Tube |             |        | Drawing     |  | Misread            | t  |                   | _          |          | _                   |             |    |                     |
|                      | Marks/Chatter Drill Hole |             |        |             | Drill Holes  |                    | Off-set                                  |                   |            |          |                     |             |    |                     |
|                      | Turning S                | Sequence    |        |             | Finish   | Out of Calibration |  |                   |            |          |                     |             |    |                     |
| ·                    | Wave/Tw                  | vist in Tul | oe     | - 1         | Fit/Function   | Out of Sequence    |  |                   |            |          |                     |             |    |                     |

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<sup>,</sup> H:/FORMS/Quality Assurance\approved QA/NCRWO RevH